

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37604 -2
Estimate Number : 11874
P.O. Number :
This Issue : 2/26/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : LARGE FAB ASSY
Previous Run : 35075
Written By :
Checked & Approved By :
Comment : Est. C 01-10-18 Added Step 10 and 11 SM
Est D 07-10-11 REVC dwg DD verified by EC

Part Number : D2207041
Drawing Number : D2207 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 3/22/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2208 End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description	Batch
2	D2208	End cap	B33743 ✓

SP 08/03/31

2.0 D22071 Housing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description	Batch
1	D2207-1	Housing	B36094 → 8x ✓ B34326 → 2x ✓

SP 08/03/31

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Chamfer D2208 and D2207-1 before welding

2-Weld as per dwg D2207

3-Grind welds flush as per Dwg D2207

SP 08.12.18 (SK)

4.0 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08/12/18 (x8)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PT

Comment: SMALL FABRICATION RESOURCE 1
Drill holes using DT8557 as per Dwg D2207

FF 09/02/25

FF 08/12/22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/25 (X6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

MO/08

09/02/25 (X6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

09-02-25 (X6)

9.0

QC3

INSPECT PC #3

SION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D2207041
13 37604
25/02/2009
S.047 15.38
#1 323.1 F
#2 30min F
#3 F
#4 F

09-02-26 (X6)

10.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Insert

Qty Part Number

Description Batch

4 ALS7-1032-130 Insert
SEE QSI 017

M108606

09-02-26 (X6)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Install AK57-1032-130 as per Dwg D2207

09-02-26 (X6)

12.0

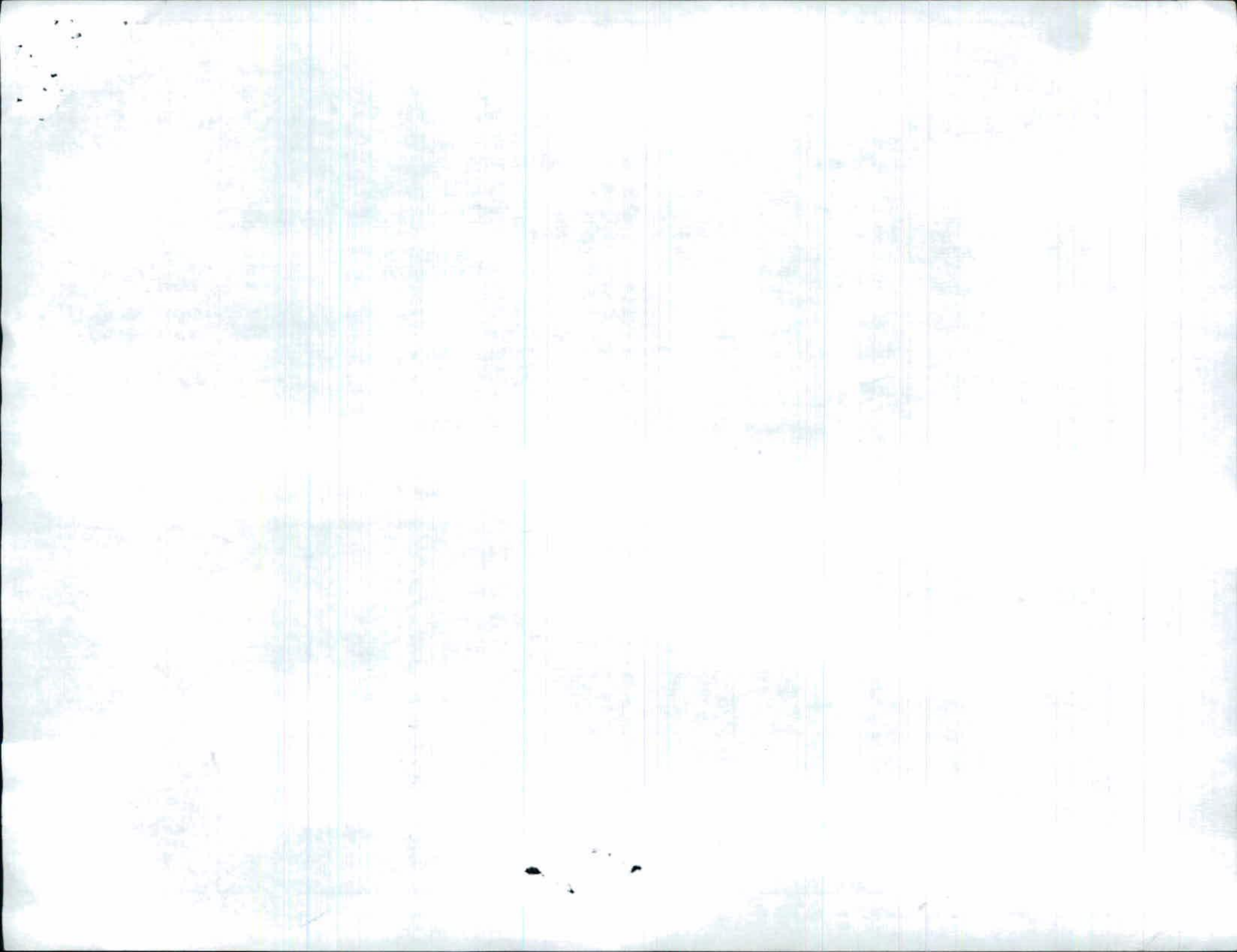
QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP






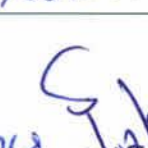


09/02/26 (X6)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2207-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>37604-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/22	5.0	1 Hole out of tolerance Drill got caught and enlarged Hole R.C: Part moved/ process.		Scrap + Destroy Not replace Replace	FF 08/12/22			
08-12-23	3.0	reweld holes on part grind flush Holes were not drilled to drawing. Were off 0.060" → 0.068" up & across.		reweld holes on part grind flush ready for redrilling + redrill with DT 9466	FF 08-12-23 09/02/24			

NOTE: Date & initial all entries

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P00 42904 x5

ST 473 x1

8/20/09 02/26/06

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/06

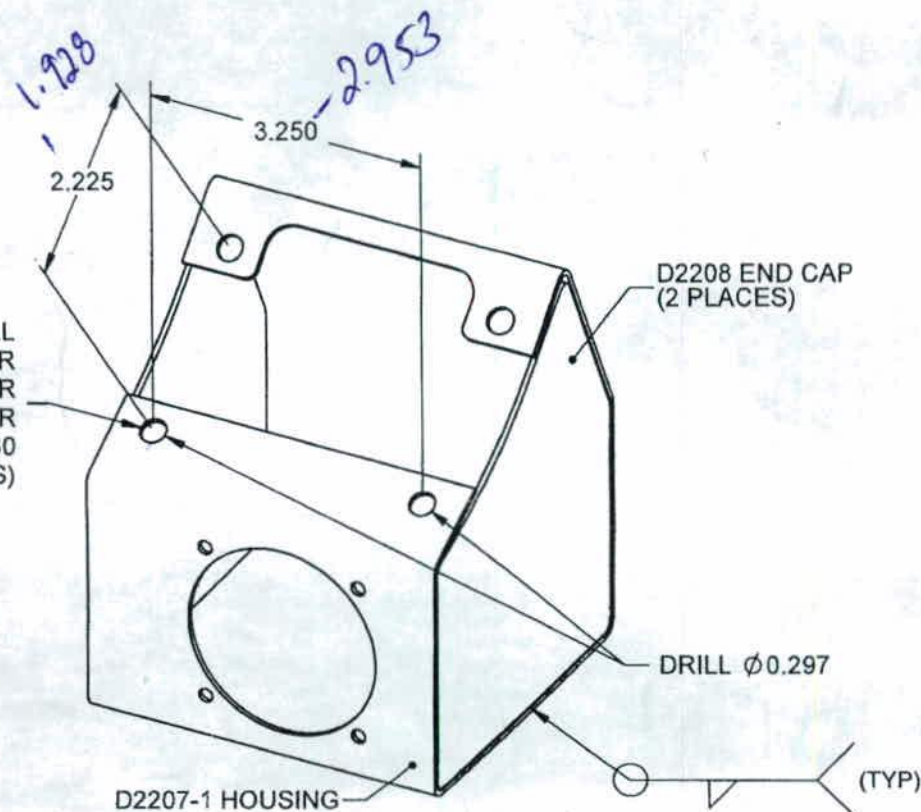
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



02/09/02/26

AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



RELEASED

07-08-29

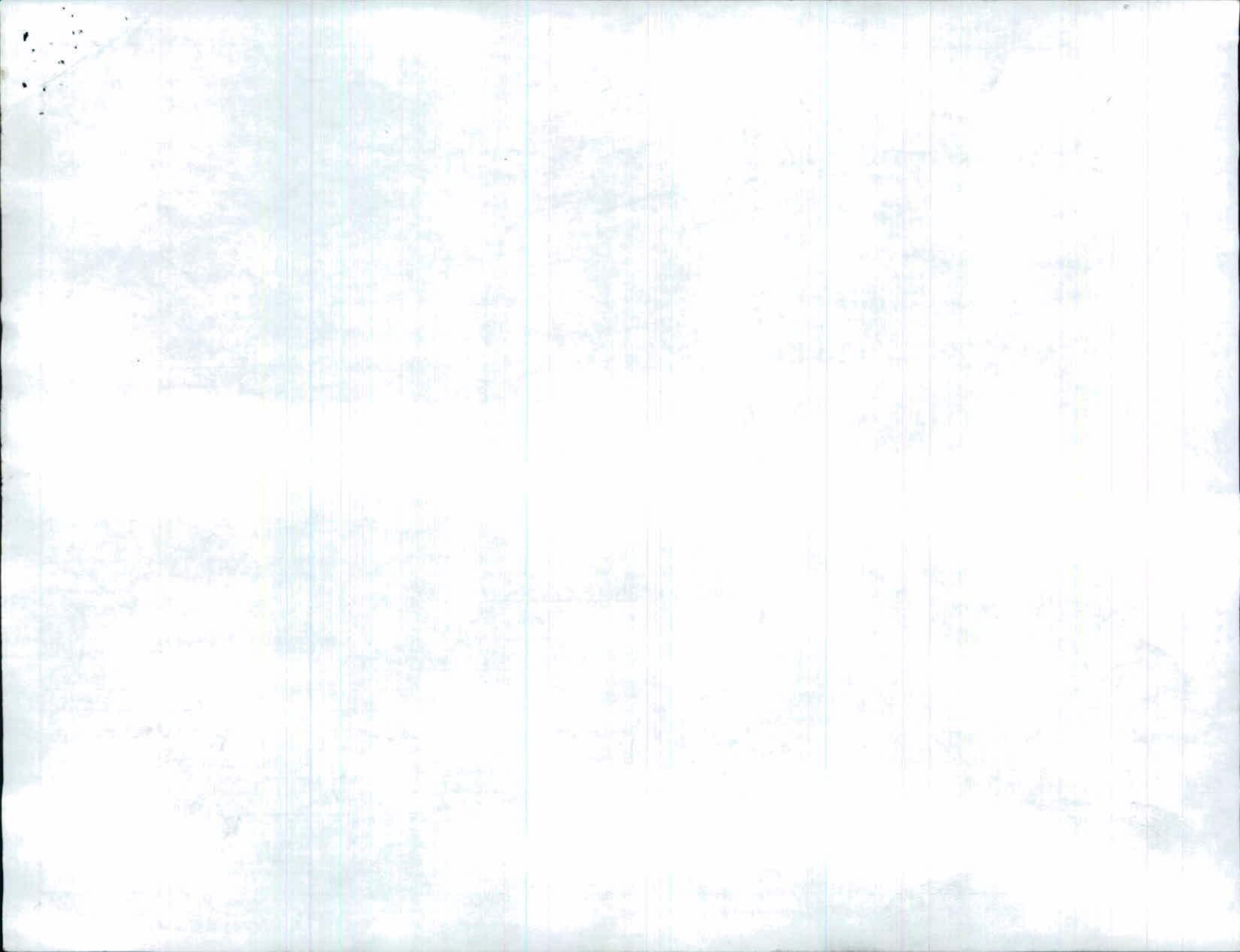
D2207-041 HOUSING ASSEMBLY

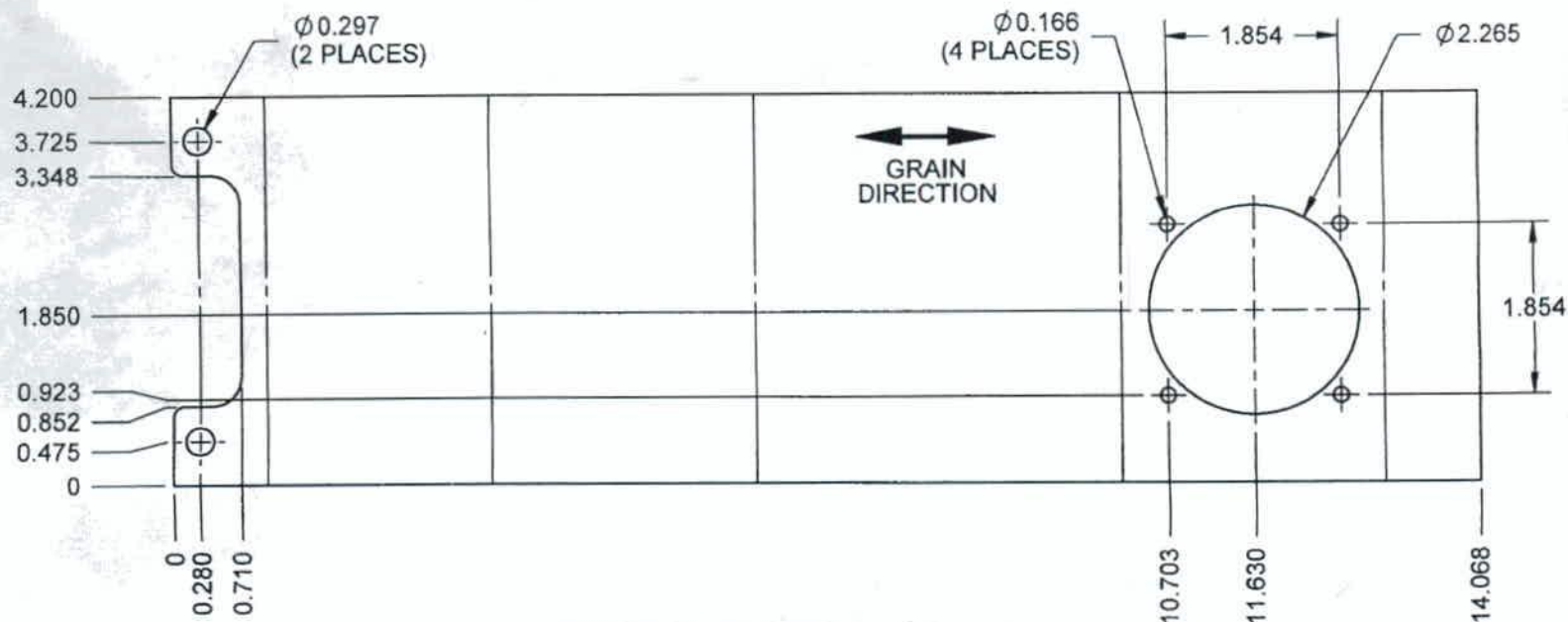
NO. 37604
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

REV.	DESCRIPTION	BY	DATE
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HOUSING	1:2
DATE	07.06.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

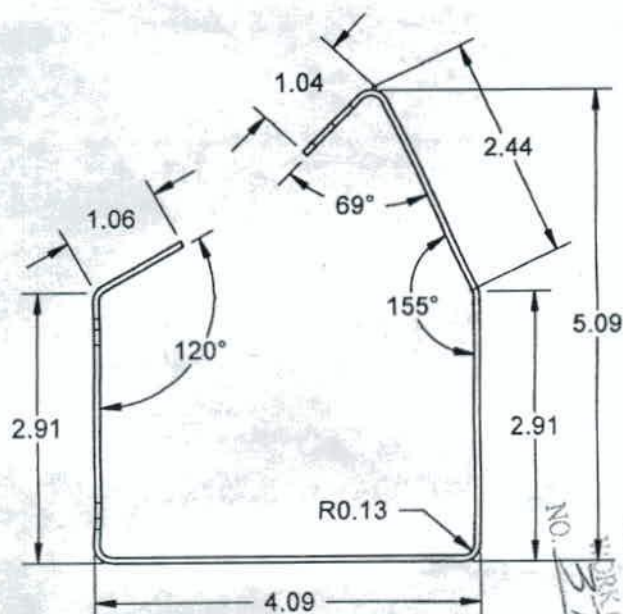




D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

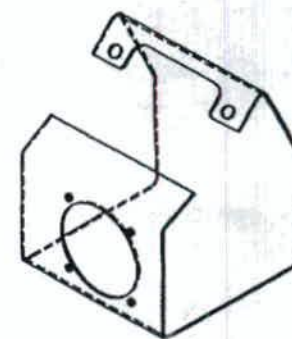


D2207-1 BENDING DETAIL

RELEASED

07.08.29

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ISOMETRIC VIEW

(SCALE 1 : 4)

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2207	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HOUSING	1:2
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